

Work Order ID 145333

Thursday, May 05, 2016 1:34:40 PM

145333

Page 1

Item ID: D119-796-251

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 5/16/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MCS Date: MAY 06 2016 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D119-796-251	D

110	Document Control	0.00
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110

DC

Memo 0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels as per PPP D119-796-251 chg 002

*Label*DAS
21
9-89

JUL 10 2016

120	Pick Kit	0.00
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120

Packaging

Packaging

Memo 0.00

Packaging

DAS
41
9-89

16-7-18

130	Crosstubes	0.00
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130

Crosstubes

Crosstubes

Memo 0.46

Crosstubes

1- Install step and clamp with the proper position per dwg D119-796-251

Torque all clamps to 50 IN-LBS max.

DAS
41
9-89
16-7-18

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Thursday, May 05, 2016 1:34:40 PM

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Page 2

Item ID: D119-796-251 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: AFT Crosstube Installation with Step (no hardware)
Start Date: 5/16/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/20/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89 JUL 18 2016
140									
QC	Memo	0.02							
Quality Control	***RE-CHECK TORQUE ON CLAMP AS PER DWG.***								
	***VERIFY BY <u>145333</u> <u>38</u> BATCH # TO MATCH W/O								
	***VERIFY BY <u>145333</u> <u>38</u> PART # TO MATCH								
	W/O <u>145333</u> <u>89</u>								
150		0.00							DAS 41 9-89 6-7-18
150	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-796-251								
	For final assembly								
160	QC21- Final Inspection - Work Order Release	0.00							DAS 21 9-89 JUL 19 2016
160									
QC	Memo	0.10							
Quality Control									

Set 7/18/16

Picklist Print

Thursday, May 05, 2016 1:34:44 PM

Page 1

Work Order ID: 145333

145333

Parent Item: D119-796-251

D119-796-251

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 5/16/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B
14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19
AS PER REV.C DD VERF:JLM IPP REV:D 14.12.09 AS PER
REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D
JLM VERF:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-796-241		Manufactured	No				Each	0.0000		1	DAS 41 9-89	16-7-6	
D119-796-241					156578				**	1			
AFT Crosstube Installation without Step (no hardware)													
D5123-3		Manufactured	No				Each	64.0000		4	DAS 41 9-89	16-7-6	
D5123-3					145850				**	4			
Clamp Cushion													
				<u>Location</u>			<u>Loc Qty</u>						
				LG055			64						
				141331			8						
				144626			56						
D5149-043		Manufactured	No				Each	6.0000		2	DAS 41 9-89	16-7-15	
D5149-043					142740				**	2			
Aft Step Base Assembly													
				<u>Location</u>			<u>Loc Qty</u>						
				LG055			6						
				142591			6						

Picklist Print

Thursday, May 05, 2016 1:34:44 PM

Page 2

Work Order ID: 145333

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Parent Item: D119-796-251

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Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 5/16/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

MS21920-25

Purchased

No

Each

32.0000

4

DAS

MS21920-25

41

9-89

16-7-7

Clamp

134987

5 -> 1 scrap

Location

Loc Qty

Loc Code

FG

10

120920

10

LG050

14

m134588

14

LG057

8

m134507

8

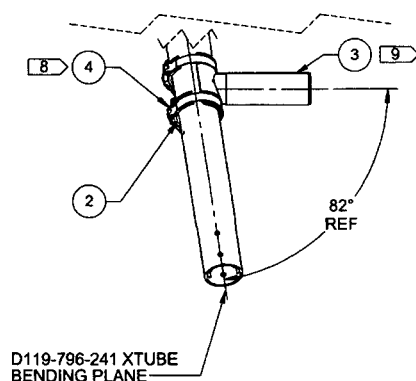
ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
2	4	D5123-3	CUSHION
3	2	D5149-043	AFT STEP ASSY
4	4	MS21920-25	CLAMP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

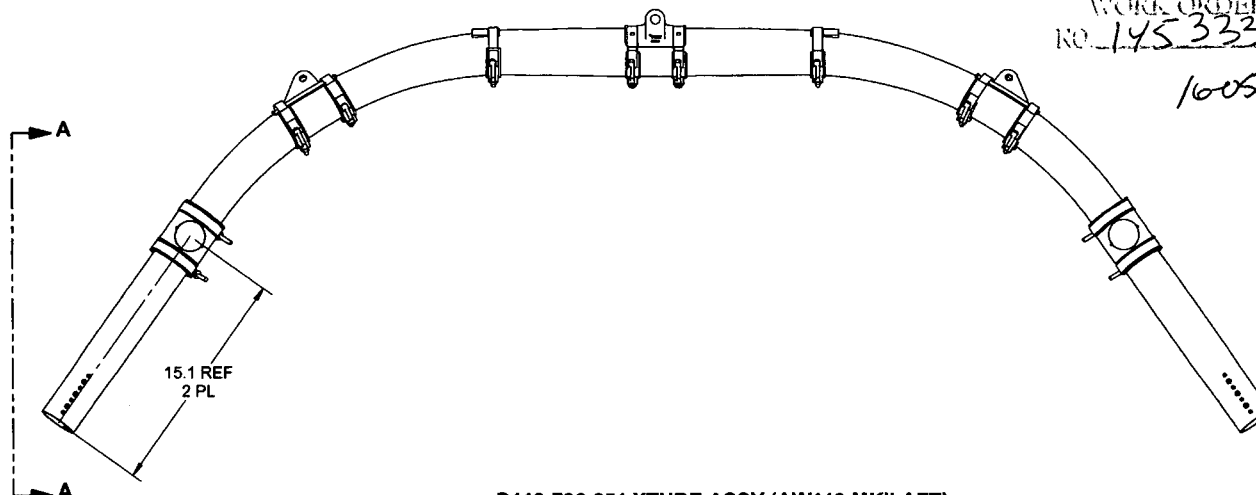
WITHOUT NOTICE
WORK ORDER

NO. 145333 MJS

1605-06



SECTION A-A



D119-796-251 XTUBE ASSY (AW119 MKII AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 29.9 lbs
- 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

RELEASED

2015 FEB 09

ECN 15-516

DESIGN	AP	DART AEROSPACE LTD	REV. D
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	SHEET 1 OF 1
CHECKED	DB	DRAWING NO.	REV. D
MFG. APPR.	DD	D119-796-251	SCALE
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT) NTS	SCALE
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